

# Work Order ID 58378

May 5, 2010 9:07:07 AM



Page 1

Item ID:	D4035-045	Accept		Setup	Start	
Revision ID:						
Item Name:	Lid Rib Assembly, Fwd (Light)			Stop		
Start Date:	05/05/2010	Start Qty:	2.00 <i>mw</i>			
Required Date:	10/05/2010	Req'd Qty:	4.00			
Reference:						

Approvals:	Process Plan:	<i>PL</i>	Date:	10-5-05	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4035	A								

100 Weld per dwg A/R Aluminum rod Batch: 11385 0.00



Large Fab

Large Fab

## Memo

- 1- Cut D4035-1 as per dwg D4035
- 2- Drill holes as per dwg D4035 using DT9562
- 3- remove identification marks and deburr
- 4- Weld bushing in rib as per dwg D4035

0.00

SAD 10-05-06

② *PL 10.06.10*

110 QC9- Inspect visual per QSI004- Fusion Welds 0.00



QC

Quality Control

## Memo

0.00

② *PL 10.06.10*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 58378**

May 5, 2010 9:07:07 AM



Page 2

Item ID: D4035-045

Accept



Setup Start



Revision ID:

Stop



Item Name: Lid Rib Assembly, Fwd (Light)

Start Date: 05/05/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 10/05/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8/10/10

2

130

Identify as per dwg &amp; Stock Location:

0.00



Packaging

Memo

0.00

Packaging

B/c

10-06-10

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/06/10

MK  
10-6-10

W/O:		WORK ORDER CHANGES					
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

May 5, 2010 9:07:11 AM

Page 1

Work Order ID: 58378

Parent Item: D4035-045

Parent Item Name: Lid Rib Assembly, Fwd (Light)

Start Date: 05/05/2010

Required Date: 10/05/2010

Comments: IPP RevA: new issue DD 10.01.25 verified by:EC  
per dwg revA 10.03.15 verified by:EC

IPP Rev:B as

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
D2953-175		Manufactured	No			100	Each	21.0000	1			
Spacer												

Location Loc Qty Loc Code

WA 21  
56985 3  
57335 18

M6061T6TS0.750W.06  
2 Purchased No

100 f 118.7279 1.875

6061-T6 SQ Tube .75 x .75 x .062W

Location Loc Qty Loc Code

MAT 41.0527  
~~114573~~ 41.0527  
MAT06 77.6752  
103069 38.0526  
104422 15.5263  
16441 4.07  
9671 20.0263

SAD 10-05-06

3.94743

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

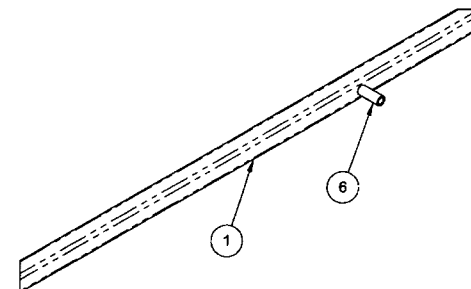
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

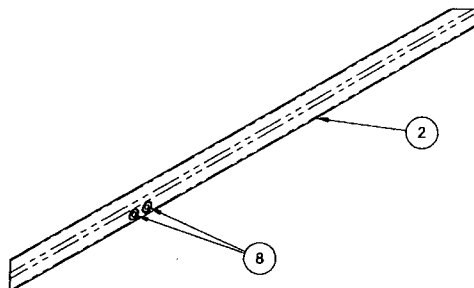
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

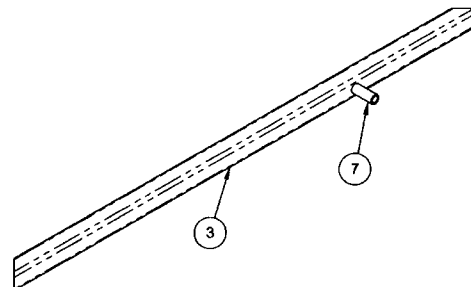
ITEM	QTY -041	QTY -043	QTY -045	QTY -047	P/N	DESCRIPTION
	X				D4035-041	LID RIB ASSY, FWD
		X			D4035-043	LID RIB ASSY, AFT
			X		D4035-045	LID RIB ASSY, FWD (LIGHT)
				X	D4035-047	LID RIB ASSY, AFT (LIGHT)
1	1				D4035-1	RIB
2		1			D4035-3	RIB
3			1		D4035-5	RIB
4				1	D4035-7	RIB
5				2	D4035-11	BUSHING
6	1				D2327-3	SPACER BUSHING
7			1		D2953-175	SPACER
8		2			D4021-9	BUSHING



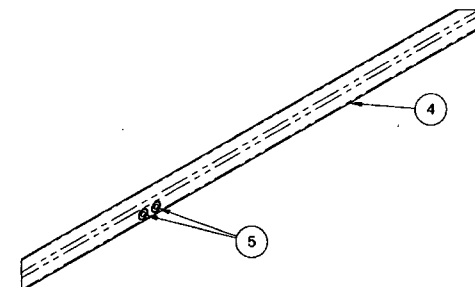
**D4035-041 BASKET LID RIB ASSY, FWD**



**D4035-043 BASKET LID RIB ASSY, AFT**



**D4035-045 BASKET LID RIB ASSY, FWD (LIGHT)**



**D4035-047 BASKET LID RIB ASSY, AFT (LIGHT)**

SHOP  
RETURN  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 38328

10-5-05

RELEASED  
2010-03-12

A NEW ISSUE		JPH	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS		
DRAWN	JPH		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.03.04		

**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D4035** REV. A  
SHEET 1 OF 5  
TITLE **BASKET LID RIB ASSY** SCALE NTS

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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

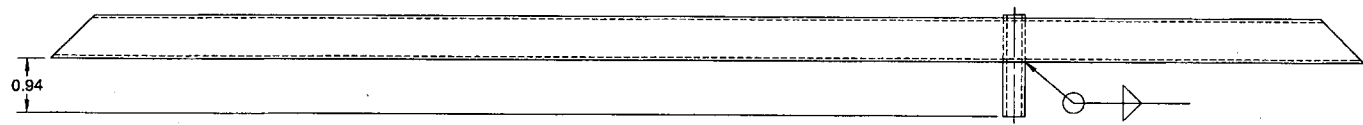
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



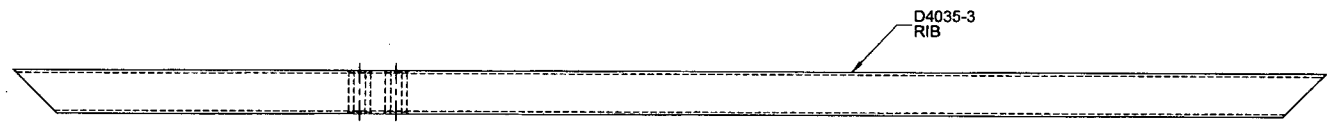
8 7 6 5 4 3 2 1



D4035-1  
RIB

D2327-3  
SPACER BUSHING

**D4035-041 BASKET LID RIB ASSY, FWD**



D4035-3  
RIB

D4021-9  
BUSHING  
2 PL

G  
G  
TYP

**D4035-043 BASKET LID RIB ASSY, AFT**

**RELEASED**  
2010-03-12  
W/O

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.83 lbs
- 8) WELDING: PER DART QSI 004

DESIGN	AJS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	JFH		
CHECKED	<i>[Signature]</i>	DRAWING NO. <b>D4035</b>	REV. A
MFG. APPR.	<i>[Signature]</i>	SHEET 2 OF 5	
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	<b>BASKET LID RIB ASSY</b>	NTS
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8 7 6 5 4 3 2 1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

8 7 6 5 4 3 2 1

D4035-5  
RIB

D2953-175  
SPACER

0.94

**D4035-045 BASKET LID RIB ASSY, FWD (LIGHT)**

D4035-7  
RIB

D4035-11  
BUSHING  
2 PL

TYP

**D4035-047 BASKET LID RIB ASSY, AFT (LIGHT)**

**RELEASED**  
2010-03-12

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.34 lbs
- 8) WELDING: PER DART QSI 004

DESIGN	AJS	<b>DART AEROSPACE LTD</b>	
DRAWN	JFH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D4035	SHEET 3 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	BASKET LID RIB ASSY	NTS
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8 7 6 5 4 3 2 1

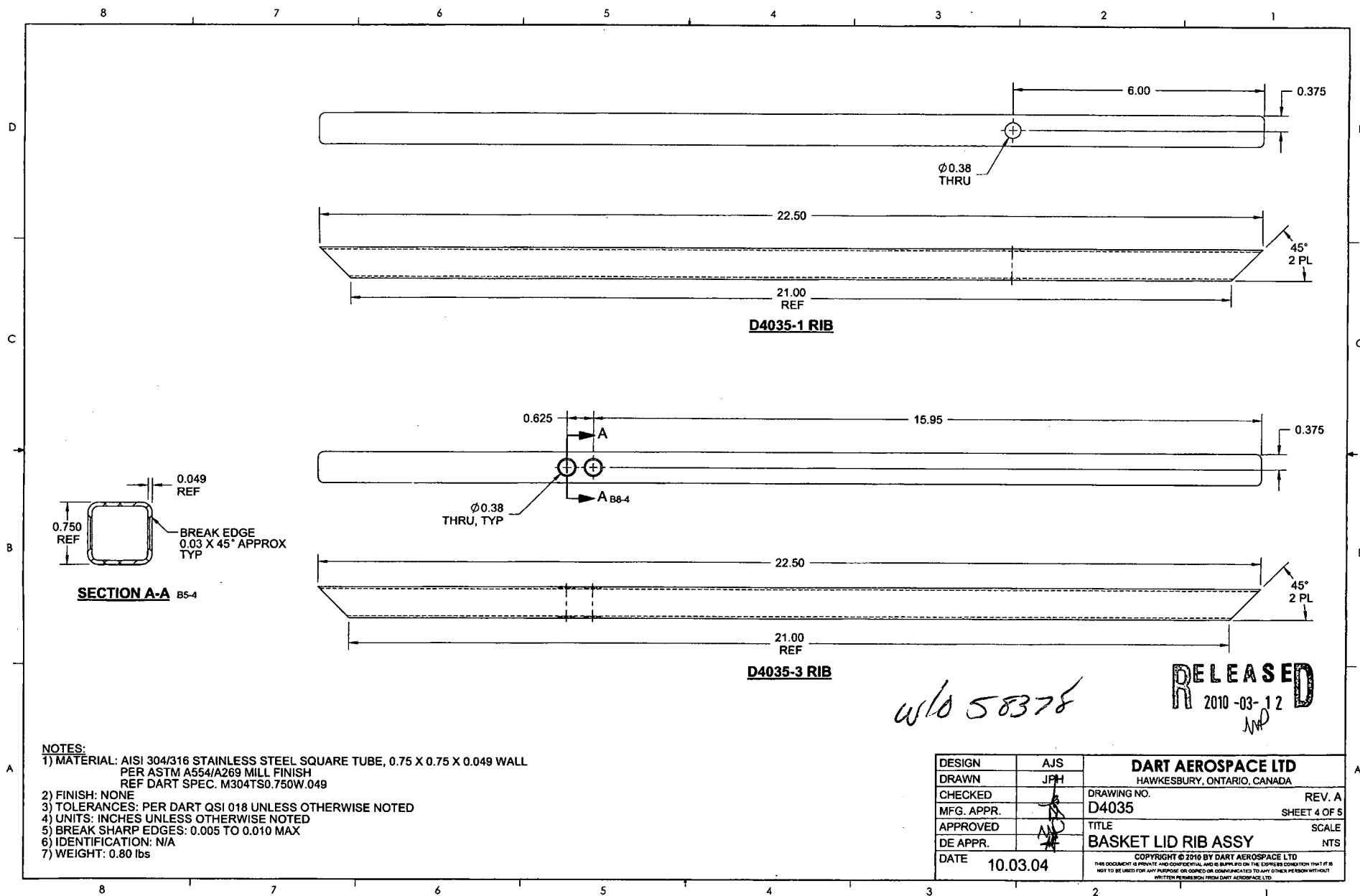
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries



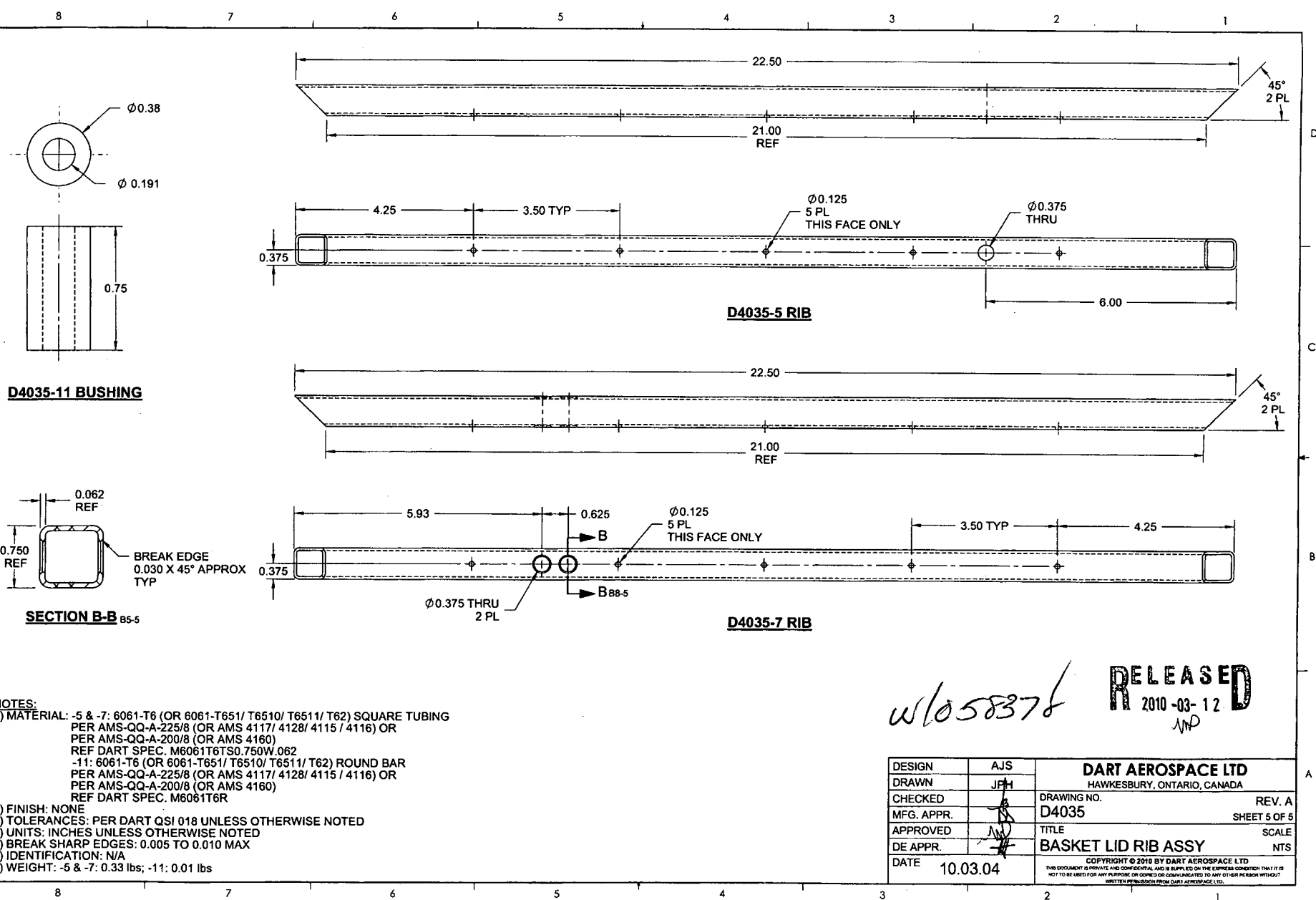
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



- NOTES:**
- 1) MATERIAL: -5 & -7: 6061-T6 (OR 6061-T651/ T6510/ T6511/ T62) SQUARE TUBING  
 PER AMS-QQ-A-225/8 (OR AMS 4117/ 4128/ 4115 / 4116) OR  
 PER AMS-QQ-A-200/8 (OR AMS 4160)  
 REF DART SPEC. M6061T6TS0.750W.062  
 -11: 6061-T6 (OR 6061-T651/ T6510/ T6511/ T62) ROUND BAR  
 PER AMS-QQ-A-225/8 (OR AMS 4117/ 4128/ 4115 / 4116) OR  
 PER AMS-QQ-A-200/8 (OR AMS 4160)  
 REF DART SPEC. M6061T6R
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: -5 & -7: 0.33 lbs; -11: 0.01 lbs

W1058376

**RELEASED**

2010-03-12

AND

DESIGN	AJS	<b>DART AEROSPACE LTD</b>	
DRAWN	JFH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<del>JS</del>	DRAWING NO.	REV. A
MFG. APPR.	<del>JS</del>	D4035	SHEET 5 OF 5
APPROVED	<del>JS</del>	TITLE	SCALE
DE APPR.	<del>JS</del>	BASKET LID RIB ASSY	NTS
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